



Dart Aerospace Ltd.
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D4072-1
Job Sheet 181519



Part No: D4072-1

Job Qty: 10 ea

Part Name: Airframe Hinge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/30/18

Job Tracking No:

Due Date: 8/17/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV B SHEET 1 Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	10 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-2		DAS 18/08/18
100	Bandsaw	10 pcs	8/17/18	8/17/18	0.00	0.15	Bandsaw1		52 18/08/18
105	CNC Vertical Machining	10 pcs	8/17/18	8/17/18	0.20	4.44	HAAS1-4		89 18/08/18
110	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-2		18/08/18
120	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-2		18/08/18
150	HandFinish	10 pcs	8/17/18	8/17/18	0.00	0.18	HandFinish1		D.R 18/08/18
160	Powdercoat	10 pcs	8/17/18	8/17/18	0.00	0.18	Powdercoat2		18/08/18
170	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC3		35 18/08/18
180	Packaging	10 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-2		21 18/08/18
190	QC21-SA	10 Ea	8/17/18	8/17/18	0.00	0.00	QC21		21 18/08/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.500	6061-T6 Bar 1.00 X 2.50	1.0400 ft (.104 ea)	90-Start up Operation	FM137365
		1.248		5099298

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.500	1	13	0

Part Specifications

Specifications could not be found.

Plex 7/30/18 12:58 PM dart.white.jesse



Container No: S099299



Part: D4072-1

Job No: 181519

Serial No/Batch: S099299

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 08/05/18

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SC
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DART AEROSPACE LTD		Work Order:	1519
Description: Airframe Hinge		Part Number:	D4072-1
Inspection Dwg: D4072 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	Ø.500 x .125	U		Ver	
2.00	+/-0.030	2.001	U		Ver	
Ø0.203	+0.005/-0.001	Ø.203	U		G.P.	
0.750	+/-0.010	0.751	U		Ver	
R0.06	+/-0.030	R.0.06	✓		R.G.	
0.45	+/-0.030	0.45	✓		Ver	
1.100	+/-0.010	1.100	U		Ver	
R0.38	+/-0.030	R.375	✓		R.G.	
0.375	+/-0.010	0.375	U		Ver	
0.688	+/-0.010	0.686	✓		Ver	
0.275	+/-0.010	0.276	✓		Ver	
R0.13	+/-0.030	R.0.13	✓		R.G.	
0.25	+/-0.030	0.248	✓		Ver	
1.06	+/-0.030	1.06	✓		Ver	
0.125	+/-0.010	0.123	✓		Ver	
0.86	+/-0.030	0.863	✓		H.G.	
Ø0.323	+0.005/-0.001	Ø.323	✓		G.P.	

DAS

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Measured by:	9-89	Audited by:	mpk	Preliminary Approval:	
Date:	18/08/04	Date:	18/08/12	Date:	

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	
B	11.10.13	Dimension 0.25 removed	KJ	